

Work Order ID 68481

Thursday, April 14, 2011 9:03:33 AM



Page 1

Item ID: D4017-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 4/14/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start

Approvals: Process Plan: HA Date: 11-04-14 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4017	C

100 0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4017
2- Drill hole as per dwg
3- Deburr and remove identify marks

SAP 11-04-26

(3)

110 0.00



QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

SAP 11-04-27

(x3)

120 0.00



Packaging

Identify as per dwg & Stock Location: WA

Memo

0.00

Packaging

SAP 11-04-27

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Page 2

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Accept



Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/14/28 JF

MF
11-04-28

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Picklist Print

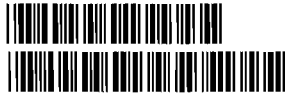
Thursday, April 14, 2011 9:03:39 AM

Page 1

Work Order ID: 68481

Parent Item: D4017-1

Parent Item Name: Rib



Start Date: 4/14/2011

Required Date: 4/21/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as
per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB
DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18
verified by:EC IPP Rev:E 11.01.18 chg qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	199.0380	4.73	14.93684			
304 SQ Tube .75x.75x.049W													

Location

Loc Qty

Loc Code

MAT018

26.5381

117029

26.5381

MAT034

172.4999

117337

172.4999

14.93684

SAD

11-04-26

W/O:		WORK ORDER CHANGES					
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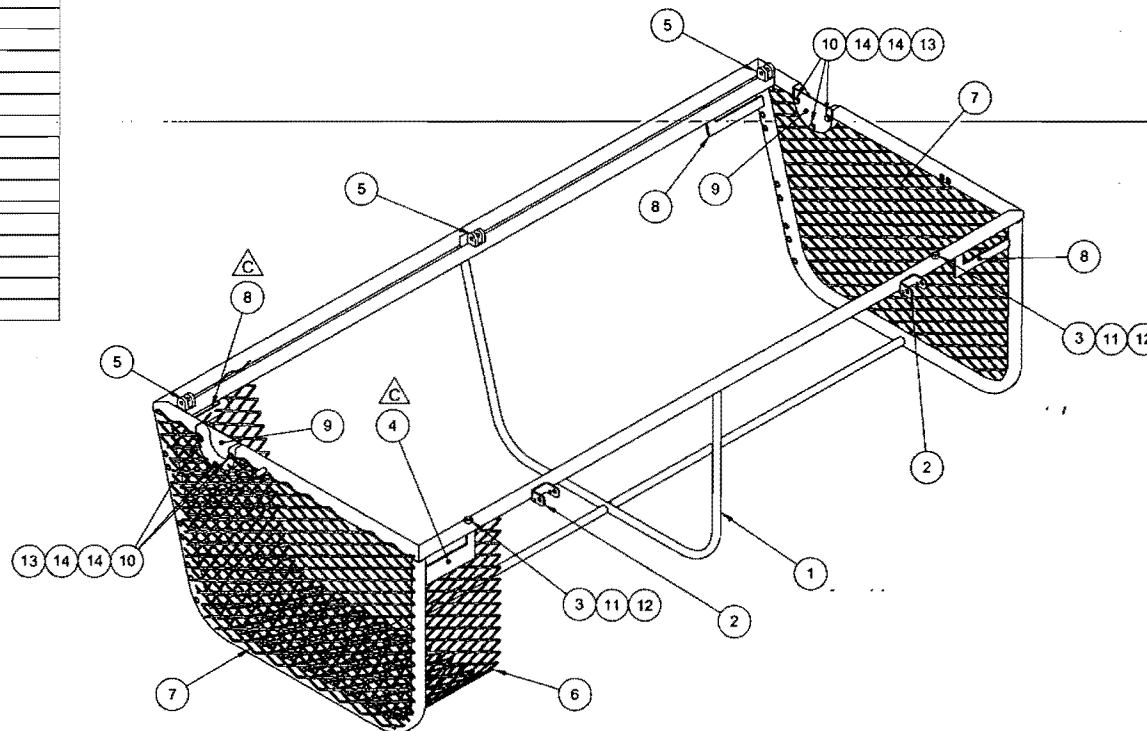
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN P-596
RELEASED
10.06.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 689461**

PL 11-046 1H

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2); REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A, NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	313.3		
APPROVED	14		
DE APPR.	14		
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4017** REV. C
SHEET 1 OF 5

TITLE **SHORT BASKET BASE ASSY (350) _NTS**
SCALE

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Dart Aerospace Ltd

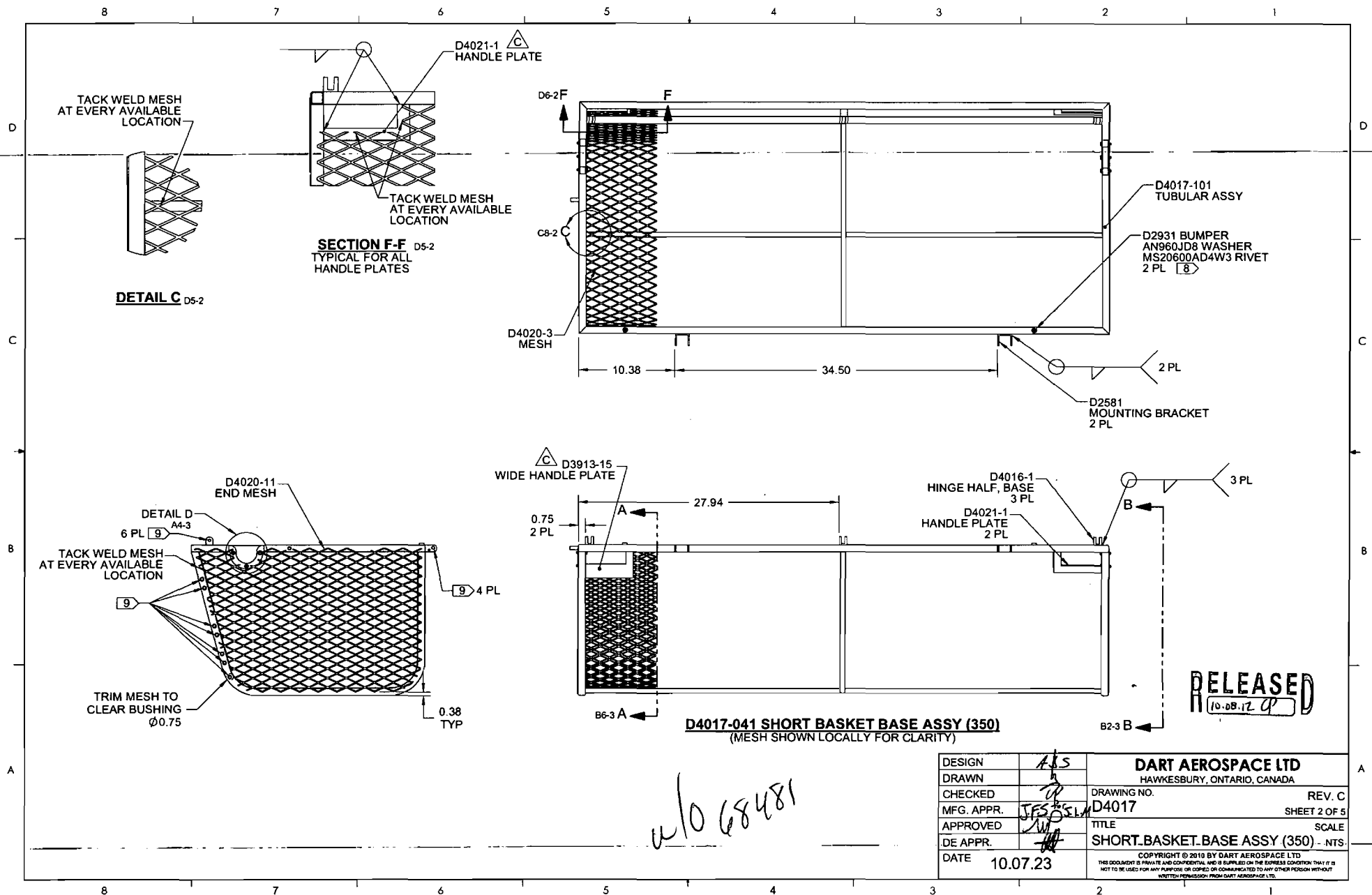
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NOTE: Date & initial all entries



DESIGN	115	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JES	D4017	SHEET 2 OF 5
APPROVED	JW	TITLE	SCALE
DE APPR.	JW	SHORT.BASKET.BASE ASSY (350) - NTS.	
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

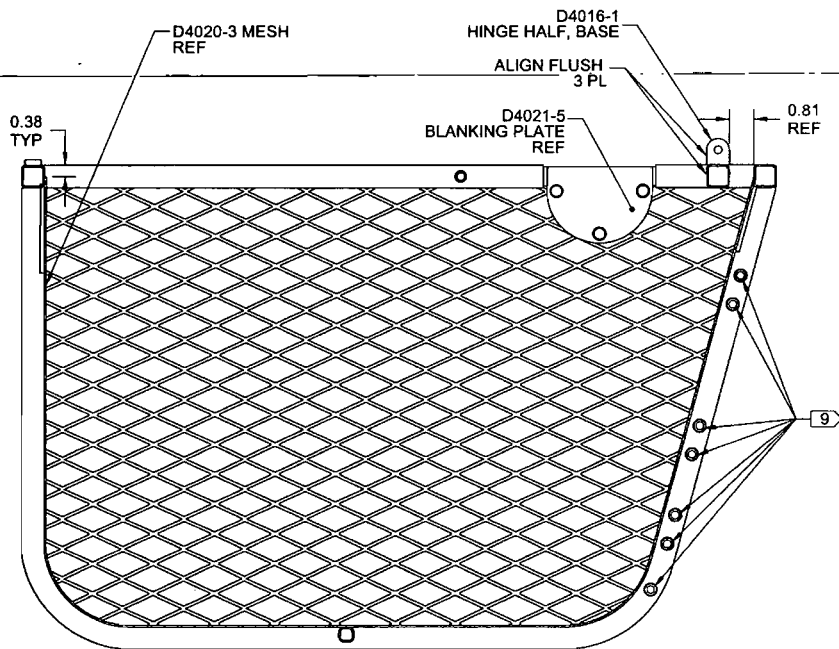
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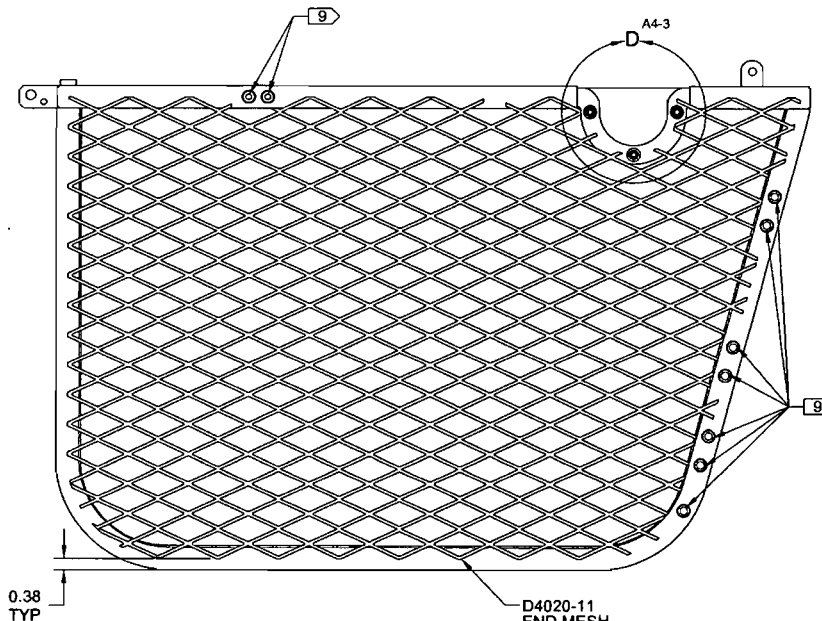
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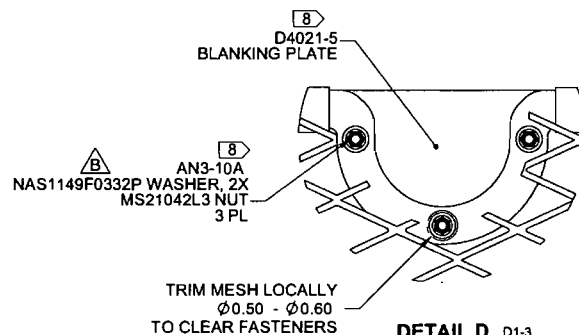
A



SECTION A-A A5-2



SECTION B-B A2-2



DETAIL D D1-3 BB-2

68481

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JFS	DRAWING NO. D4017	REV. C
MFG. APPR.	JFS	SHEET 3 OF 5	
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	SHORT-BASKET-BASE ASSY (350) - NTS	
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8 7 6 5 4 3 2 1

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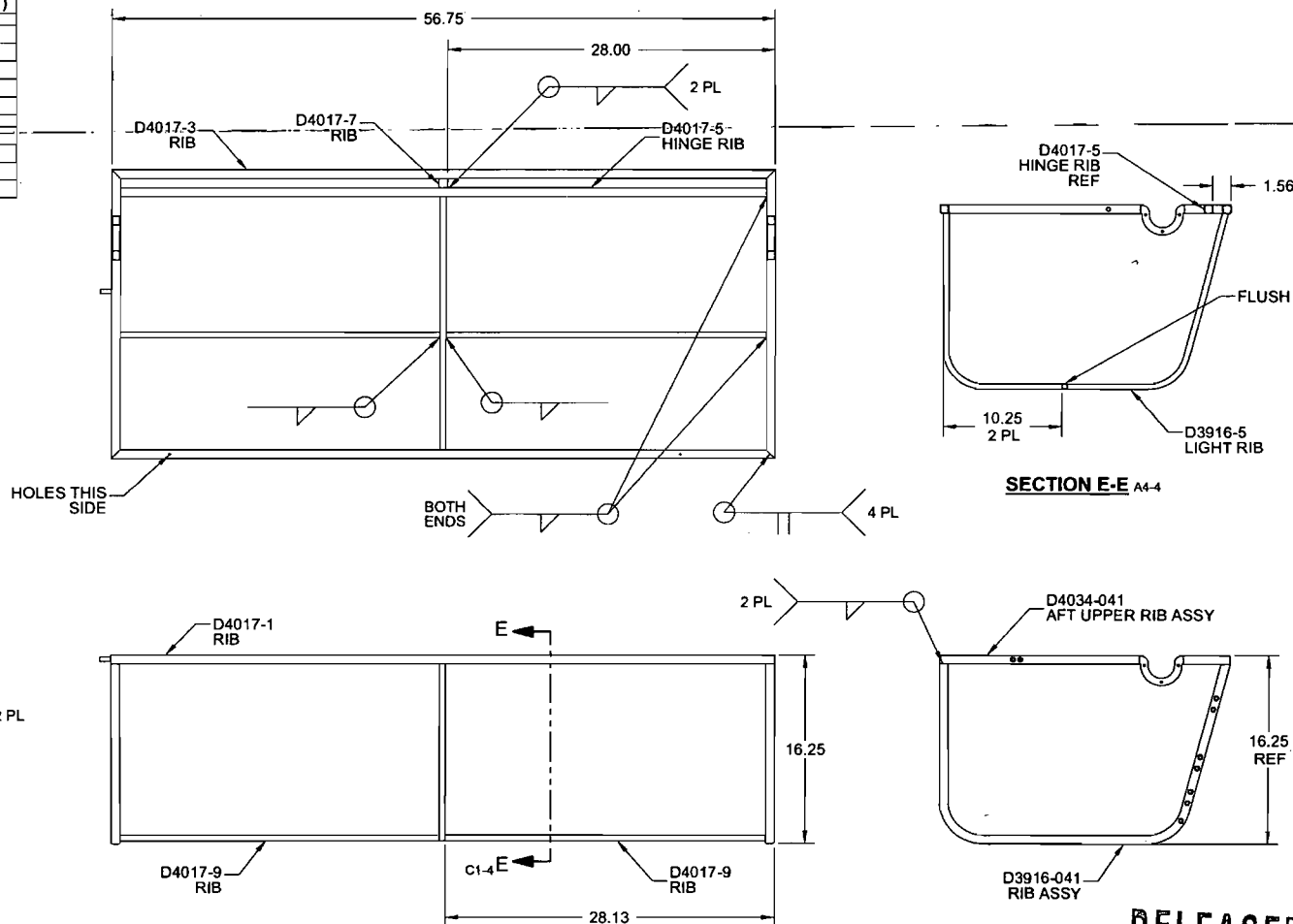
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NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	W	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W	DRAWING NO. D4017	REV. C
MFG. APPR.	SFS	TITLE	SHEET 4 OF 5
APPROVED	W	SHORT BASKET-BASE ASSY (350) NTS	SCALE
DE APPR.	W		
DATE	10.07.23		

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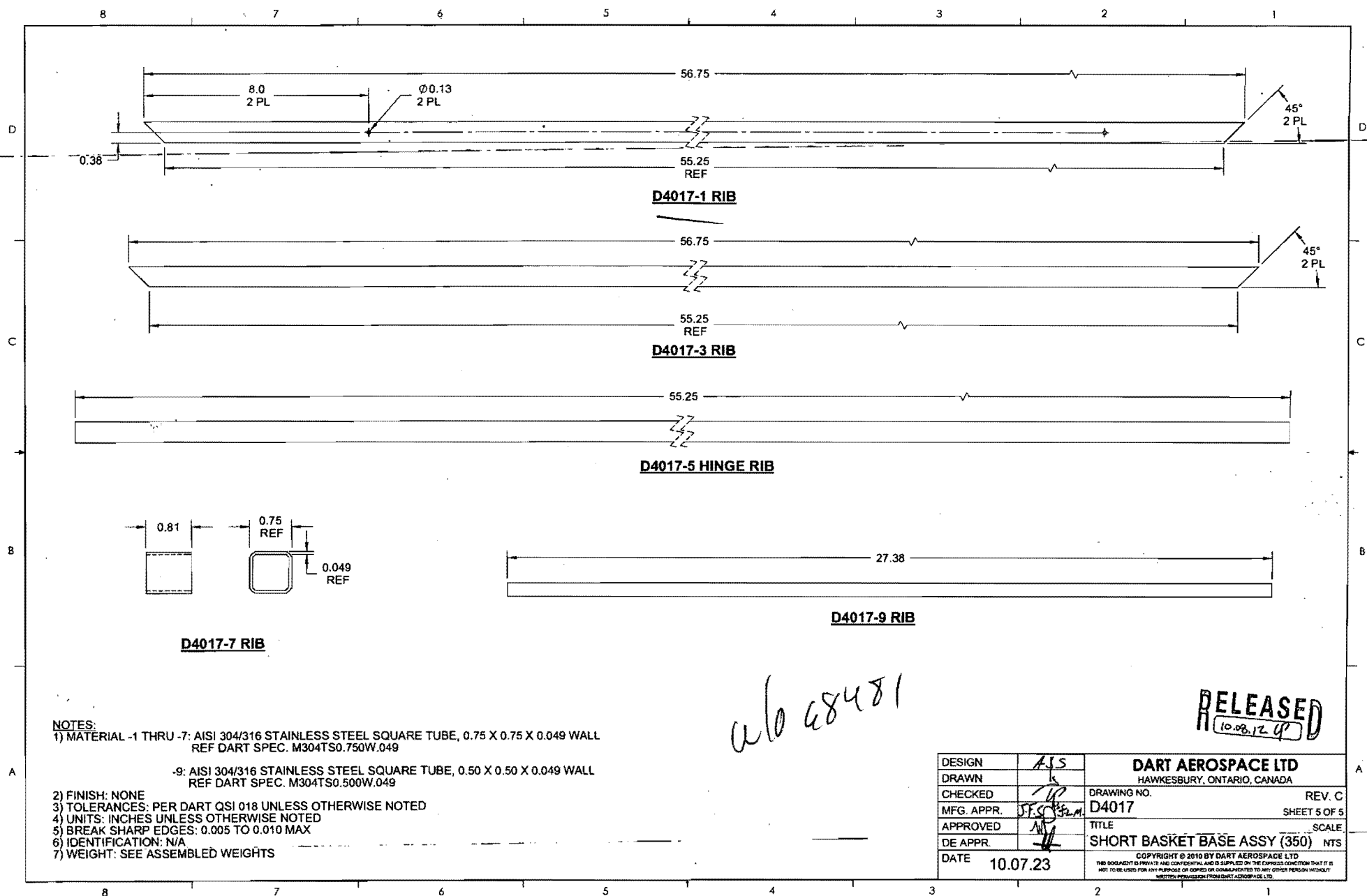
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NOTES:

- 1) MATERIAL -1 THRU -7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

2648481

RELEASED
10.08.12.47

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D4017	REV. C
MFG. APPR.	J.F. S. M.	SHEET 5 OF 5	
APPROVED	JP	TITLE SCALE	
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